

Date: Monday, 10/30/2006 4:16:08 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |               |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : SPACER      |
| Job Number            | : 29238                               |                  |               |
| Estimate Number       | : 11167                               |                  |               |
| P.O. Number           | : <i>N/A</i>                          | Part Number      | : D32783      |
| This Issue            | : 10/30/2006 S.O. No. : <i>N/A</i>    | Drawing Number   | : D3278 REV B |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A         |
| First Issue           | : <i>N/A</i> Type : SMALL /MED FAB    | Drawing Revision | : B           |
| Previous Run          | : 28274                               | Material         | : <i>N/A</i>  |
| Written By            | : <i>[Signature]</i>                  | Due Date         | : 11/24/2006  |
| Checked & Approved By | : <i>[Signature]</i> 061031           | Qty:             | 40 Um: Each   |
| Comment               | : Est. A04.04.19 New issue KJ/JLM     |                  |               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                 |              |
|-----|-----------------|--------------|
| 1.0 | MDELINS0125X300 | Black Delrin |
|-----|-----------------|--------------|



Comment: Qty.: 0.0361 sf(s)/Unit Total: 1.4448 sf(s)

Black Delrin

Use DT8685 Router Table.

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0)

Identify for D3278-3

Batch: *M101657*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

SAD 06:11:04

(40)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:11:04

(40)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK




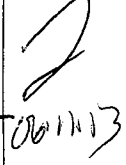
SAD 06/11/06

(38)

(40)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/11/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)               |  |                                 |                |  |  |  |
|----------|------|--|--|---------------------------------|----------------|--|--|--|
| DATE     | STEP | Description of NC<br>Section A                 | Corrective Action Section B  |                                 |                | Verification<br>Section C  | Approval<br>Chief Eng  | Approval<br>QC Inspector   |
|          |      |  | Initial<br>Chief Eng   | Action Description<br>Chief Eng | Sign &<br>Date |  |  |  |
| 06/11/06 | 4    | 2 scrap due to<br>blow holes from<br>water jet |  | destroy<br><br>(2 scrap)        | JH<br>06/11/08 | <br>06/11/06 | <br>05/12/06 | <br>06/11/06 |
|          |      |  |  |                                 |                |  |  |  |
|          |      |  |  |                                 |                |  |  |  |

NOTE: Date & initial all entries

-Date: Monday, 10/30/2006 4:16:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 29238

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D3278

2-Deburr

FF 06-11-09

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51418

Boe/11/10 (38)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/08

Job Completion



u 06/11-10

→ 5.1

Qc 5

inspect work to  
current step

06/11/09

(38)

(Pto)

u

Dart Aerospace Ltd

| W/O:     |              | WORK ORDER CHANGES                 |          |                      |     |                                     |                          |
|----------|--------------|------------------------------------|----------|----------------------|-----|-------------------------------------|--------------------------|
| DATE     | STEP         | PROCEDURE CHANGE                   | By       | Date                 | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 06/11/09 | <del>1</del> | QC5 inspection<br>permanent change | MS<br>FE | 06/11/09<br>06-11-09 |     | U<br>06/11/09                       | J<br>06-11-13            |
|          |              |                                    |          |                      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

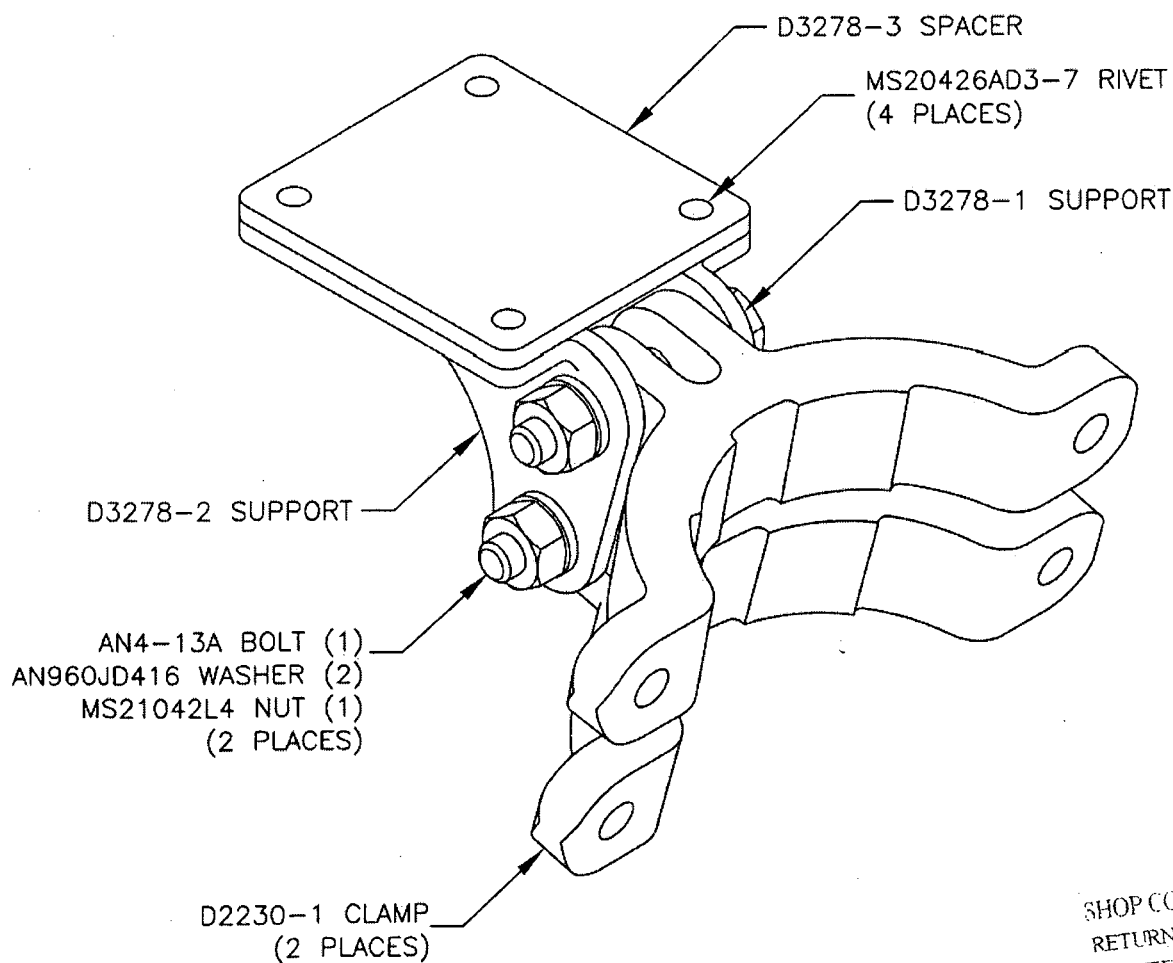




|                        |                         |   |                        |
|------------------------|-------------------------|---|------------------------|
| DESIGN<br>CP           | DRAWN BY<br>CP          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3278                              | REV. B<br>SHEET 1 OF 3 |
| DATE<br>05.03.31       |                         | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>NTS           |
| A                      | 04.03.03                | NEW ISSUE   |                        |
| B                      | 05.03.31                | CHANGE DIM/TOL TO ENSURE FIT                      |                        |

RELEASED  
05.04.04 [Signature]



## D3278-041 SUPPORT ASSEMBLY



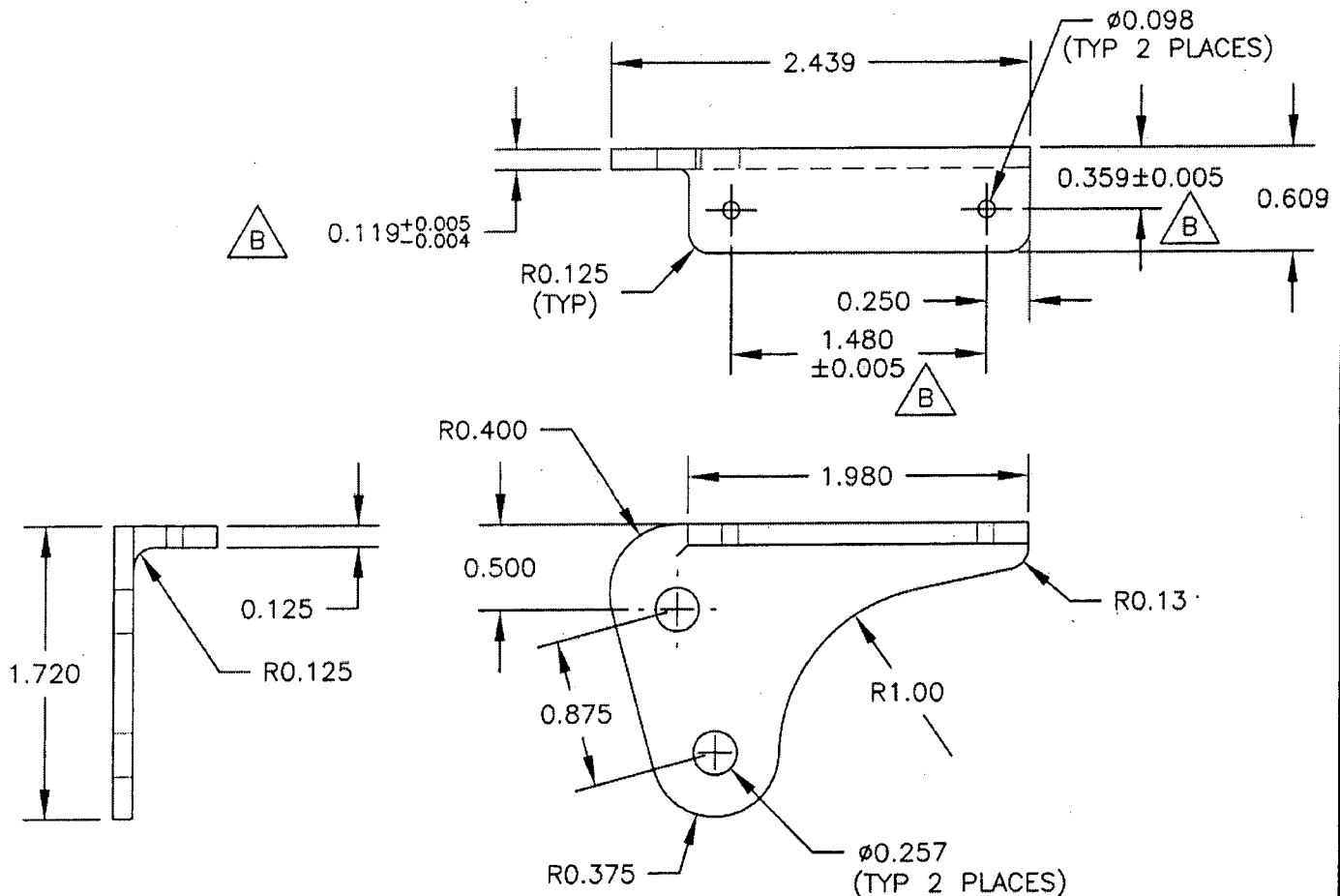
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29238

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

|  |   |   |                        |
|--|---|---|------------------------|
| DESIGN<br>CP   | DRAWN BY<br>CP  | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br> | APPROVED<br> | DRAWING NO.<br>D3278                              | REV. B<br>SHEET 2 OF 3 |
| DATE<br>05.03.31   |   | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>1:1           |

05.04.04



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"  
2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
4) BREAK ALL SHARP EDGES 0.005 TO 0.015  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES
- SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 2923

QQ-A SHOP COPY  
256/11)  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
D WORK ORDER  
NO. 29238

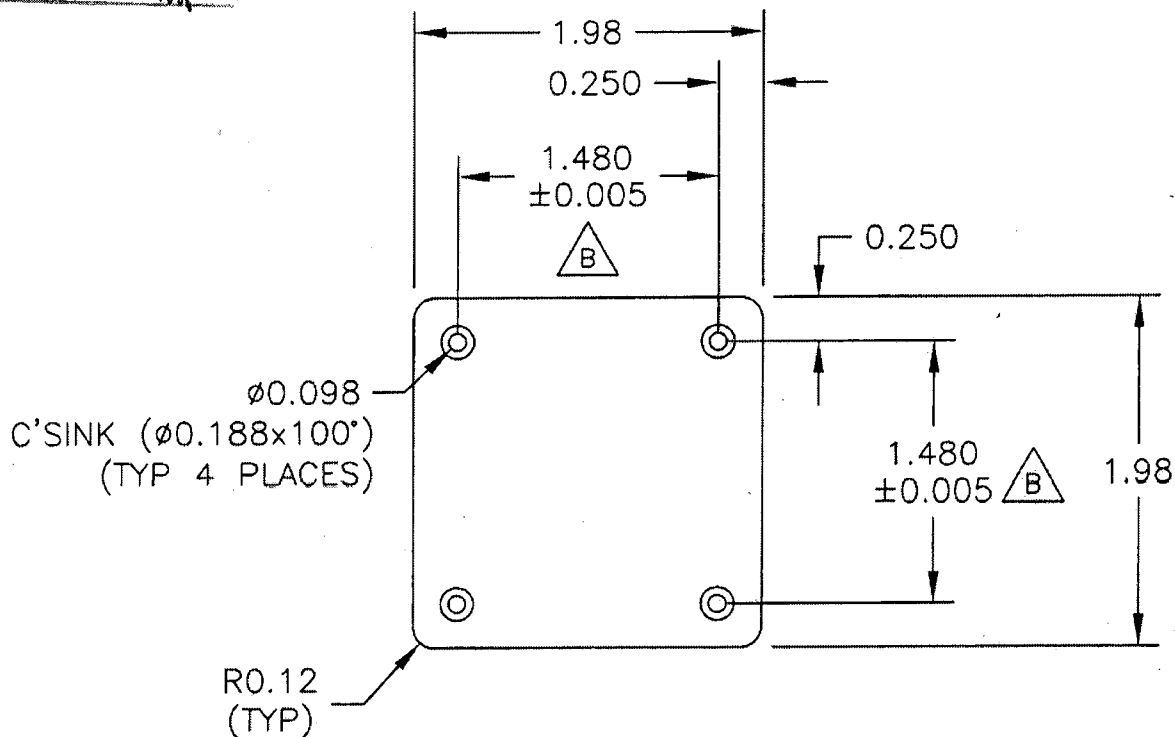
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>CP                  | DRAWN BY<br>CP                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3278                              | REV. B<br>SHEET 3 OF 3 |
| DATE<br>05.03.31              |                                | TITLE<br>SUPPORT ASSEMBLY                         | SCALE<br>1:1           |

RELEASED

05.04.04 *[Signature]***D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-C  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **29238**

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.